Thursday, 10/18/2007 8:03:13 AM Kim Johnston User: **Process Sheet** : CROSSBOLT SPACER Drawing Name : CU-DAR001 Dart Helicopters Services Customer Job Number : 35210 : 10752 **Estimate Number** Part Number : D32751 :NIA: P.O. Number S.O. No. : 1 · D3275 REV A1 **Drawing Number** : 10/18/2007 This Issue : N/A Project Number Prsht Rev. : MACHINED PARTS **Drawing Revision** First Issue : 34619 **Material** Previous Run .100 Um: Each : 11/2/2007 **Due Date** Written By Checked & Approved By New issue KJ/JLM 04.10.19 Comment **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: ALUM. SEAMLESS TUBE 1.0 M6061T6T03125W058 0.2799 f(s)/Unit Total: 27.9930 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) Ø0.313" x 0.058" wall (M6061T6T0.3125W.058)I dentify as D3275-1 2.0 Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA469 and Dwg D3275 3.0 QC2 DIP 07/11/10 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 Comment: SECOND CHECK PACKAGING RESOURCE #1 PACKAGING 1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock ST. 80 Location:\_\_\_

Dart Ae	rospace	Ltd							
W/O:			WC	ORK ORDER CHANGES	S				
DATE	STEP	PRO	CEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	lo) DQA:	5	Date: _	Mulla
					QA: N/O	C Closed:		_ Date: _	
NCR:		V	VORK ORDI	ER NON-CONFORMAN	ICE (NCR)	1			
		Description of NC		Corrective Action Section	В	Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector

		Description of NC	Scription of NC Corrective Action Section B			Verification	Annessal	Annassal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date:

Thursday, 10/18/2007 8:03:14 AM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 35210

Part Number: D32751

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



N 07(162

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				<del></del>			
Part No	:	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	

					QA: N/	C Closed:	_ Date: _	
NCR:		1	WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B		Verification			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
		,						
			·					

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 35210

Description: Crossbolt Spacer

Part Number: D3275-1

Inspection Dwg: D3275 Rev: A1

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	T-1	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
3.180	+/-0.010	3,180				
0.025 - 0.030	N/A	0.025	V.			
45°	+/-0.01°	0.025				
Ø0.313	+0.010/-0.005	0.312	/			
Ø0.197	+0.005/-0.000	0.197	<b>V</b>			
0.058	Max = 0.0605 Min = 0.0555	0.057	<b>√</b>	· · · · · · · · · · · · · · · · · · ·		
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Measured by: 55	Audited by:	Prototype Approval:	N/A
Date: 07/11/10	Date: 67.11.10	Date:	N/A

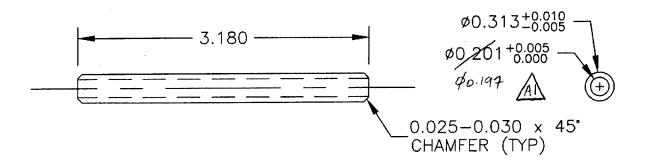
0.4.40.46			
A 04.10.19	New Issue	KJ/JLM 1,A	
B 06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM 🛠	411





DESIGN	P	DRAWN BY	DART AEROSPACE U	
CHECKE	D M	APPROVED 14	DRAWING NO.	REV. A
	41-	1 At	D3275	SHEET 1 OF 1
DATE			TITLE	SCALE
04.03	3.10		CROSS BOLT SPACER	1:1
Α	<i>y.</i> J	04.03.10	NEW ISSUE	
AI .	cell	04.10.19	CHANGE MAT'L SPEC	

RELEASED 04.do.222



## D3275-1 CROSS BOLT SPACER

1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)

(REF DART SPEC. M6061T6R) M6061T6T0.313W.058 AN

2) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 35210

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